

Work Order ID 80346

February-17-12 8:35:37 AM

80346

Page 1

Item ID: D3552-15 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Door Prop
 Start Date: 17/02/2012 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 02/03/2012 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: M.L.S Date: 12/02/17 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3552	J								

100 PURCHASING 0.00
100
 Purchasing Memo 0.00
 Purchasing Issue P/O: 16217
 Purchase Part Number: B8-154-387-300N
 Supplier: LS Technologies
 Certificate of conformity is required

12-02-17
 (6)

110 Receive & Inspect for Damage & Mat'l Certs 0.00
110
 Packaging Memo 0.00
 Packaging Ensure certificate of conformity is attached

01/4/22 (6)

120 QC6- Inspect dimensions to drawing 0.00
120
 QC Memo 0.00
 Quality Control Test for correct pressure

12-02-22 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Required Date: 02/03/2012 Req'd Qty: 6.00 *6* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: 272	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

12/2/22 5/160

M.L.J 12/02/23

R12-02-23

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

February-17-12 8:35:40 AM

Page 1

Work Order ID: 80346

80346

Parent Item: D3552-15

D3552-15

Parent Item Name: Door Prop

Start Date: 17/02/2012

Required Date: 02/03/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 10.09.24 new issue DD Verf:EC
10.12.03 as per dwg rev.G DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

B8-154-387-300N

Purchased

No

110

Each

0.0000

1

6

B8-154-387-300N

**

Gas Spring

16/02/22 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

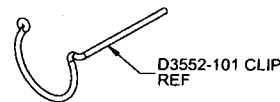
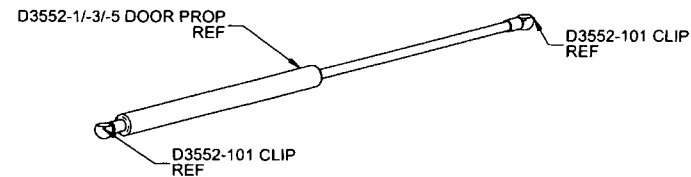
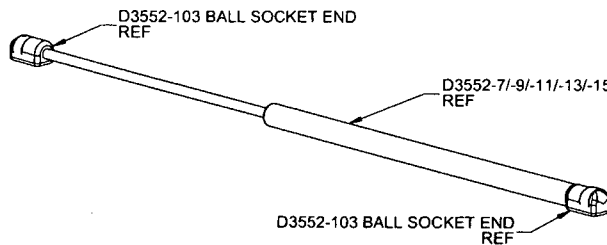
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NOTE: Date & initial all entries

SPECIFICATION CONTROL DRAWING



RELEASED
2011-12-13

SHOP
RETURN
ENGINEER
UNCONTROLLED
SUBJECT TO APPROVAL
WITHOUT
WORK ORDER
NO. 80346 M.C.J
12/02/17

J	ADD P/N D3552-25/-27. REMOVE ALTERNATE PART NUMBER FOR -15, -17 AND -19. STROKE FOR -15, -17 AND -19 WAS 139/6.06 NOW 154/6.06. EXTENDED LENGTH FOR -15, -17 AND -19 WAS 386/15.2 NOW 387/15.2	AP	11.12.07
I	ADD P/N D3552-23	RF	11.10.11
H	ADD P/N D3552-21	DC	11.03.10
G	FOR -15, FORCE: 300/67.4 WAS 400/89.9, SUPPLIER P/N B8-154-387-300N WAS B8-154-387-400N; FOR -17, STROKE: 139/5.47 WAS 160/6.30, EXT LG: 386/15.2 WAS 407/16.0, SUPPLIER P/N B8-154-387-156N WAS B8-167-408-156N	JPH	10.11.01
F	ADD P/N D3552-15/-17/-19 AND ALTERNATE SUPPLIER	JPH	10.07.27
E	ADD P/N D3552-13 ZN B8-1, A8-1, D6-1, CHANGE NAME FROM "GAS SPRING" TO "DOOR PROP" THROUGH OUT DWG	HS	10.02.03
D	ADD P/N D3552-101 ZN D6-1, C7-1, C1-1 AND D3552-103 ZN D1-1 AND C2-1 AND ZN B8-1; ADD NOTE REGARDING D3552-101 AND D3552-103 COMPATIBILITY ZN A8-1	HS	09.04.02
C	ADD D3552-11 AND CONVERSIONS FOR INSPECTION; UPDATE P/N FOR D3552-7	LE	07.06.01
B	ADD D3552-7/-8; UPDATE DESC. D3552-1/-3/-5	LE	06.10.24
A	NEW ISSUE	LE	06.09.15
REV.	DESCRIPTION	BY	DATE

DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED		DRAWING NO. D3552	REV. J
MFG. APPR.			SHEET 1 OF 2
APPROVED		TITLE DOOR PROP	SCALE NTS
DE APPR.		COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	11.12.07		

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

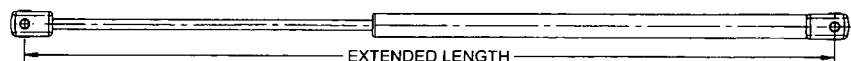
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NOTE: Date & initial all entries

80346



DART PART NUMBER	DESCRIPTION	STROKE (mm/in)	EXTENDED LENGTH (mm/in)	FORCE (N/lb)	END FITTING	MATERIAL	SUPPLIER	SUPPLIER PART NUMBER OR MODEL NUMBER
D3552-1	DOOR PROP	220/8.66	530/20.6	70/15.7	10mm SS BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	C8-220-530-070N
D3552-3	DOOR PROP	200/7.87	490/19.3	200/45.0	10mm SS BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	C8-200-490-200N
D3552-5	DOOR PROP	175/6.89	430/16.9	150/33.7	10mm SS BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	C8-175-430-150N
D3552-7	DOOR PROP	220/8.66	530/20.9	70/15.7	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-220-530-070N
D3552-9	DOOR PROP	200/7.87	490/19.3	200/45.0	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-200-490-200N
D3552-11	DOOR PROP	240/9.45	575/22.6	150/33.7	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-240-575-150N
D3552-13	DOOR PROP	220/8.66	530/20.9	140/31.5	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B6-220-530-140N
D3552-15	DOOR PROP	154/6.06	387/15.2	300/67.4	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-154-387-300N
D3552-17	DOOR PROP	154/6.06	387/15.2	156/35.1	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-154-387-156N
D3552-19	DOOR PROP	154/6.06	387/15.2	60/13.5	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-154-387-060N
D3552-21	DOOR PROP	167/6.57	410/16.1	70/15.7	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B6-167-410-070N
D3552-23	DOOR PROP	190/7.48	475/18.7	70/15.7	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B6-190-475-070N
D3552-25	DOOR PROP	148/5.83	475/18.7	300/67.4	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-148-475-300N
D3552-27	DOOR PROP	148/5.83	475/18.7	156/35.1	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-148-475-156N
D3552-103	BALL SOCKET END	N/A	N/A	N/A	N/A	NYLON	LS TECHNOLOGIES	B10
D3552-101	CLIP	N/A	N/A	N/A	N/A	CARBON STEEL	LS TECHNOLOGIES	C9

D3552-X DOOR PROP

RELEASED
2011-12-13

NOTES:

- 1) IDENTIFICATION: IDENTIFY PER QSI 044 6.2
- 2) D3552-103 BALL SOCKET END IS ONLY COMPATIBLE WITH D3552-7/-9/-11/-13/-15/-17/-19/-21/-23/-25/-27 DOOR PROPS
- 3) D3552-101 CLIP IS ONLY COMPATIBLE WITH D3552-1/-3/-5 DOOR PROPS

DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	JK	DRAWING NO.	REV. J
MFG. APPR.	JK	D3552	SHEET 2 OF 2
APPROVED	JK	TITLE	SCALE
DE APPR.	JK	DOOR PROP	NTS
DATE	11.12.07	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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NOTE: Date & initial all entries



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO16217**

Purchase Order Date 2/17/2012

PO Print Date 2/17/2012

Page Number 1 of 1

Order From :

VC-LST0001

LS TECHNOLOGIES INC.
314 JESSOP AVE
SASKATOON, SK S7N 1Y6
CA

Contact Name
Vendor Phone 306 683 5000
Vendor Fax 306 683 6403
Vendor Account Nbr

Buyer Brigitte Golden
Requisition Nbr
Tax Resale Nbr 10127-2607
Terms Net 30
Currency CAD
FOB Destination-Collect

Ship To :

DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	B8-240-575-150N	GAS SPRING	2/15/2012 Yes	24.00 Each	FedEx PI collect	\$41.3640	\$992.74
		Special Inst:	AS PER DWG: D3552 REV: J B80345				
2	B8-154-387-300N	Gas Spring	2/15/2012 Yes	6.00 Each	FedEx PI collect	\$26.5000	\$159.00
		Special Inst:	AS PER DWG: D3552 REV: J B80346				
3	B6-190-475-070N	Door Prop	2/15/2012 Yes	12.00 Each	FedEx PI collect	\$32.5000	\$390.00
		Special Inst:	AS PER DWG: D3552 REV: J B80347				

PO Total: \$1,541.74

Change Nbr: 2

Change Date: 2/17/2012

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

LS TECHNOLOGIES INC

314 Jessop Ave
Saskatoon, SK S7N 1Y6

Ph # (306) 683-5000

Packing Slip

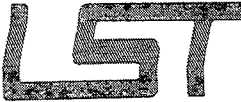
P.O. No.	Date	Invoice #
16217	17/02/2012	8274

Name / Address
Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

Ship To
Main Finished Goods Location Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

Ship	Via	FOB
17/02/2012	Fed-Ex	

Qty	Description
24	B8-240-575-150N Gas spring
6	B8-154-387-300N Gas Spring
12	B6-190-475-070N Gas Spring
Shipping Via FED EX Tracking # 798073727926	



LS Technologies Inc

314 Jessop Ave

Saskatoon, SK, S7N 1Y6

Ph: (306) 683-5000 Fax: (306) 683-6403

Certificate of Compliance

This is to certify that the parts listed below meets specifications as required by your order.

Feb 17, 2012

24 Units: B8-240-575-150N Carbon Steel Gas Spring

6 Units: B8-154-387-300N Carbon Steel Gas Spring

12 Units: B6-190-475-070N Carbon Steel Gas Spring

Country of Manufacture: Canada

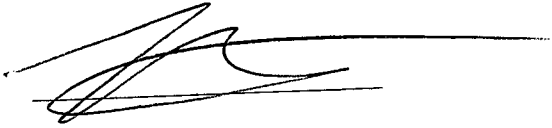
Date of Manufacture : Feb 2012

This product is ROHS compliant.

Purchase Order # 16217

Invoice # 8274

L S Technologies Inc Canada



Nolan Fehr
Manager